

PHACT MS0001N

This product is a nucleating agent masterbatch designed to accelerate the crystallization kinetics of semi-crystalline PHA. We recommend using approximately 1 weight percent of this masterbatch in compounds containing semi-crystalline PHA. This nucleation masterbatch helps shorten cycle times and processing in all conventional polymer processing operations including injection molding, extrusion, sheet/thermoforming, film (blown and cast) and extrusion coating. It is based PHACT S1000P. Please consult your sales/technical representatives for details.

PROPERTIES OF PHACT DEV 10

Properties	Units	ASTM No	DEV 5
Forms	-		Pellet
Specific Gravity	-	D792	1.25
Melt Flow Rate (190°C, 2.16Kg)	g/10 min	D1238	1.0

PROCESSING CONDITIONS - EXTRUSION

Drying Temperature	75 °C X 4 hrs	Compression/Melting	170 °C
Feed Temperature	25 ~ 40 °C	Metering	165 °C
Solids Conveying	170 °C	All Die Zones	150 ~ 160 °C

Moisture: MS0001N will be supplied in pellet form in aluminum foil-lined packaging with a moisture content of 400 ppm or less when packed. A moisture content of less than 0.04% (400ppm) is highly recommended to prevent viscosity degradation during processing. Typical drying conditions are 4 hours at 75 °C (167 °F) with a dew point of -40 °C (-40 °F). The resin should not be exposed to atmospheric conditions after drying. Keep the package sealed until ready to use and promptly reseal any unused material.

Safety: MS0001N must be handled and processed with adequate ventilation and proper personal protective equipment. Temperatures above 190°C (374°F) can result in considerable polymer degradation.

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